

FIG. 1

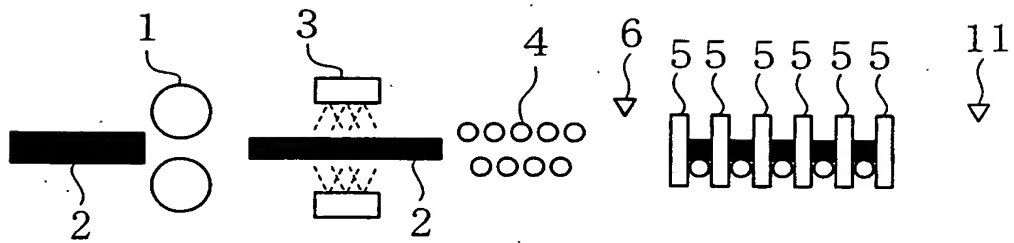
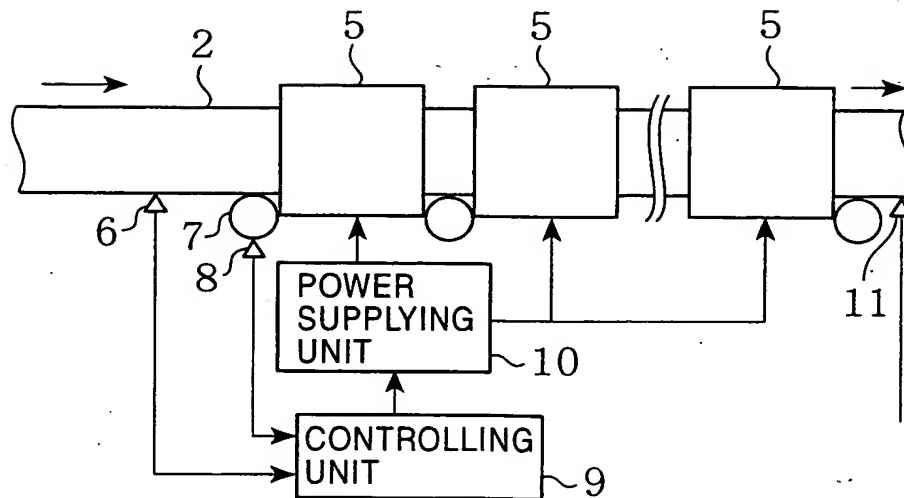


FIG. 2



2/14

FIG. 3A

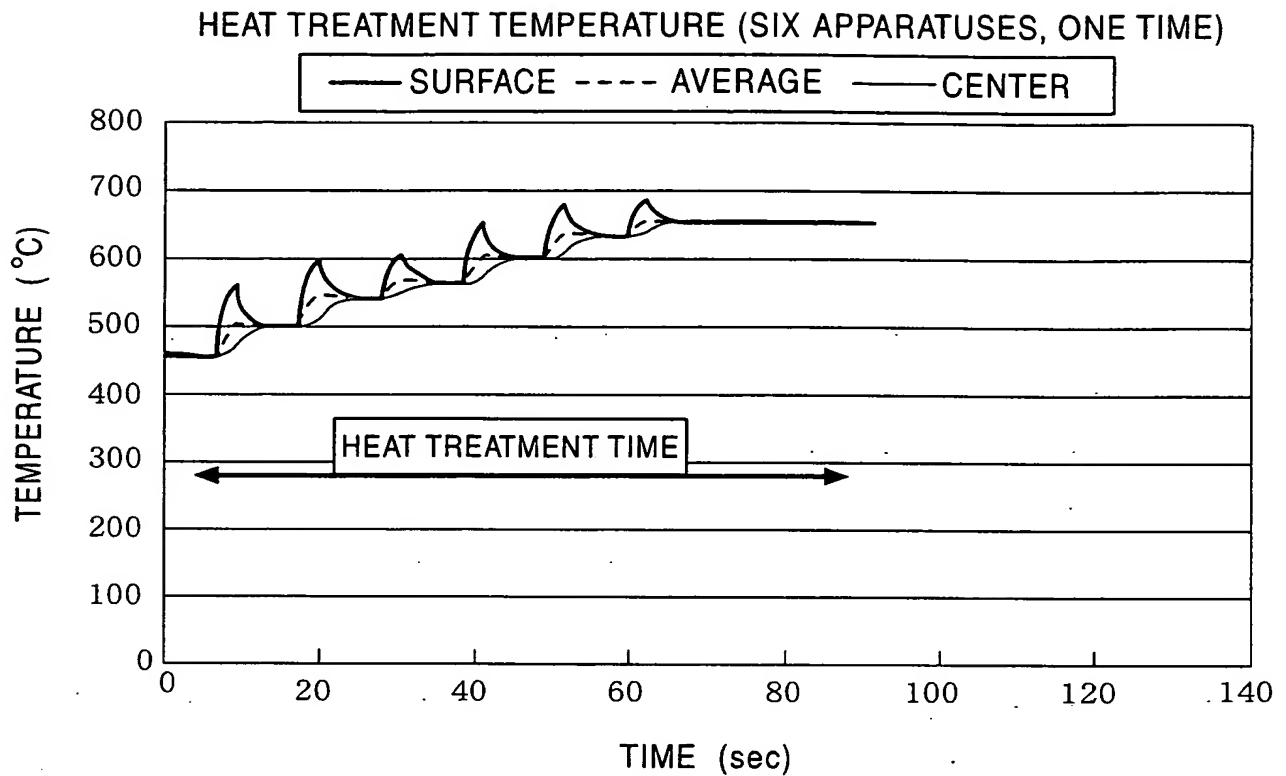
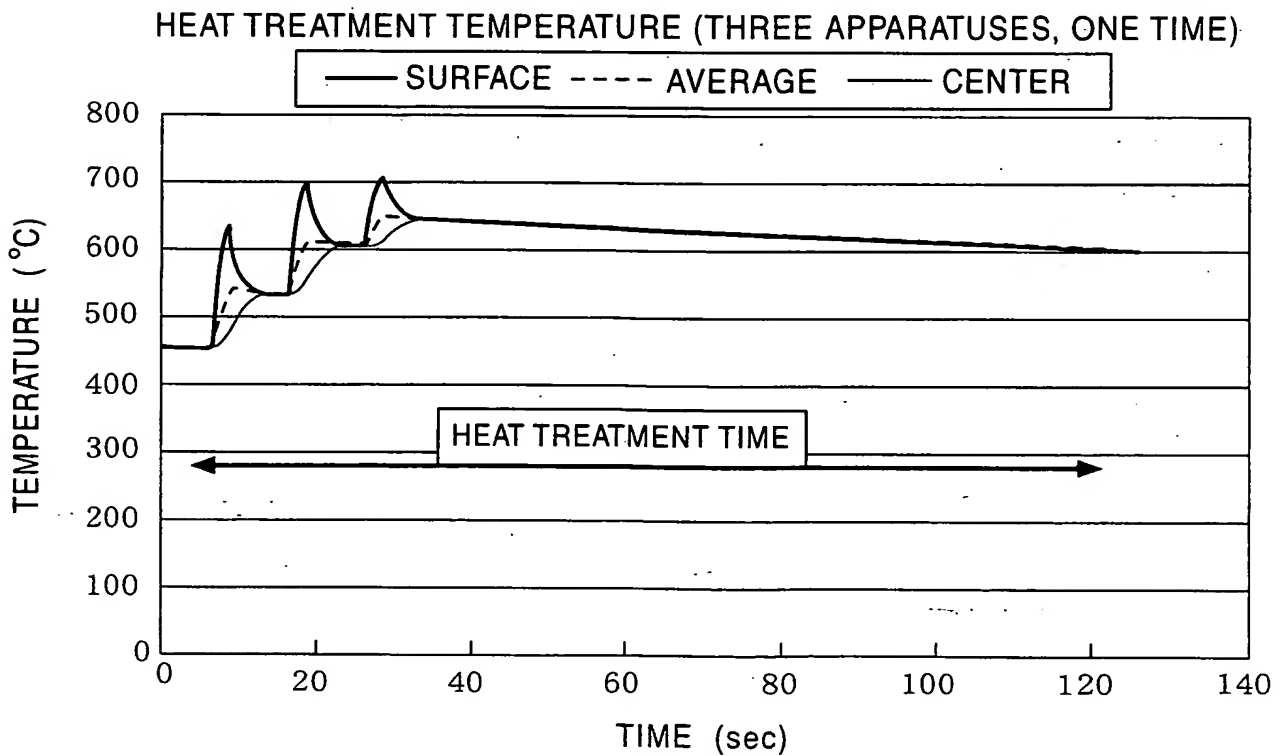


FIG. 3B



3/14

FIG. 3C

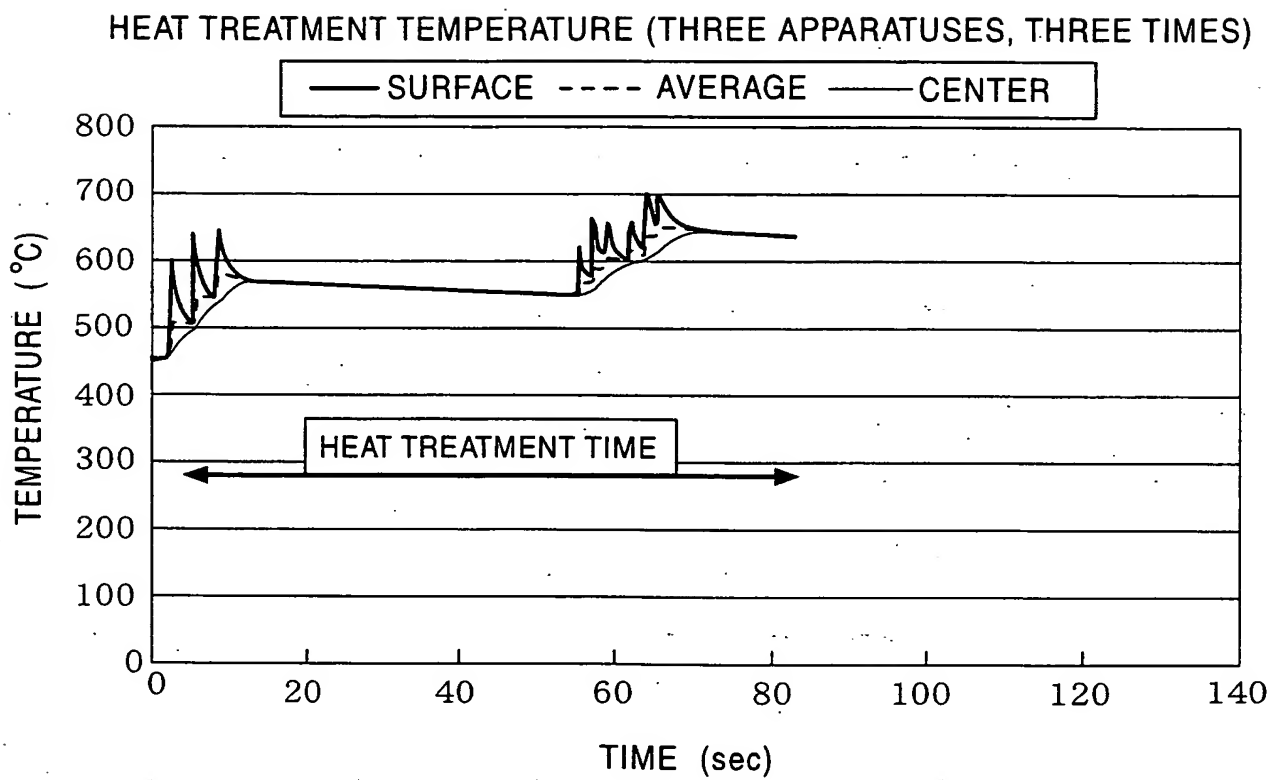


FIG. 4

NUMBER OF TIMES OF PASSAGE WITH PRIORITY IN TREATMENT TIME
(IN CASE OF THREE INDUCTION HEATING APPARATUSES)

THICK- NESS	15mm	TARGET TEMPERATURE					20mm	THICK- NESS	25mm	TARGET TEMPERATURE					25mm	THICK- NESS	TARGET TEMPERATURE						
		INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C				650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C			620 °C	650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C
15m	200 °C		1	3	3	3	200 °C	15m	200 °C						15m	200 °C							
	300 °C	3	1	3	3	3	300 °C			3	1	3	3	3			300 °C	3	3	3	3	3	5
	400 °C	1	1	3	3	3	400 °C			1	3	3	3	3			400 °C	3	3	3	3	3	5
25m	200 °C		1	3	3	3	200 °C	25m	200 °C						25m	200 °C							
	300 °C	1	1	3	3	3	300 °C			3	3	3	3	3			300 °C	3	3	3	3	5	X
	400 °C	1	1	3	3	3	400 °C			1	3	3	3	3			400 °C	3	3	5	5	5	X
35m	200 °C		1	3	3	3	200 °C	35m	200 °C						35m	200 °C							
	300 °C	1	1	1	3	3	300 °C			3	3	3	3	3			300 °C						
	400 °C	1	1	3	3	3	400 °C			1	3	3	3	3			400 °C						

THICK- NESS	30mm	TARGET TEMPERATURE					35mm	THICK- NESS	40mm	TARGET TEMPERATURE					40mm	THICK- NESS	TARGET TEMPERATURE						
		INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C				650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C			620 °C	650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C
15m	200 °C		3	3	3	3	X	15m	200 °C						15m	200 °C							
	300 °C		3	3	3	3	X			300 °C								300 °C					
	400 °C		3	3	3	3	X																
25m	200 °C		3	3	3	5	X	25m	200 °C						25m	200 °C							
	300 °C		3	3	5	5	X			300 °C								300 °C					
	400 °C		3	3	5	5	X																
35m	200 °C		—	—	—	—	—	35m	200 °C						35m	200 °C							
	300 °C		—	—	—	—	—			300 °C								300 °C					
	400 °C		—	—	—	—	—																

X : UNABLE TO HEAT — : NO CORRESPONDING MATERIAL

FIG. 5

NUMBER OF TIMES OF PASSAGE WITH PRIORITY IN ELECTRIC POWER CONSUMPTION RATE
(IN CASE OF THREE INDUCTION HEATING APPARATUSES)

THICK- NESS	15mm	TARGET TEMPERATURE					THICK- NESS	20mm	TARGET TEMPERATURE					THICK- NESS	25mm	TARGET TEMPERATURE							
		INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C			650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C			620 °C	650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C	650 °C
15m	200 °C	1	1	1	1	1	3	15m	200 °C	1	1	1	1	3	15m	200 °C	1	1	3	3	3		
	300 °C	1	1	1	1	3	3		300 °C	1	1	1	1	3		3	300 °C	1	1	3	3	3	
	400 °C	1	1	1	1	3	3		400 °C	1	1	1	1	1		3	400 °C	1	1	3	3	3	
25m	200 °C	1	1	1	1	1	3	25m	200 °C	1	1	1	1	3	25m	200 °C	1	1	3	3	X		
	300 °C	1	1	1	1	1	3		3	300 °C	1	1	1	1		3	3	300 °C	1	1	3	3	X
	400 °C	1	1	1	1	1	3		3	400 °C	1	1	1	1		1	3	400 °C	1	1	3	3	X
35m	200 °C	1	1	1	1	1	3	35m	200 °C	1	1	1	1	3	35m	200 °C	—	—	—	—	—		
	300 °C	1	1	1	1	1	3		3	300 °C	1	1	1	1		3	3	300 °C	—	—	—	—	—
	400 °C	1	1	1	1	1	3		3	400 °C	1	1	1	1		1	3	400 °C	—	—	—	—	—

THICK- NESS	30mm	TARGET TEMPERATURE					THICK- NESS	35mm	TARGET TEMPERATURE					THICK- NESS	40mm	TARGET TEMPERATURE					
		INITIAL TEMPERATURE	550 °C	575 °C	600 °C	620 °C			650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C			620 °C	650 °C	INITIAL TEMPERATURE	550 °C	575 °C	600 °C
15m	200 °C	1	3	3	3	3	X	15m	200 °C	3	3	3	3	X	15m	200 °C	3	3	3	—	—
	300 °C	1	3	3	3	3	X		300 °C	3	3	3	3	X		300 °C	3	3	3	—	—
	400 °C	1	3	3	3	3	X		400 °C	3	3	3	3	X		400 °C	3	3	3	—	—
25m	200 °C	1	3	3	3	3	X	25m	200 °C	3	3	3	3	X	25m	200 °C	3	3	3	5	—
	300 °C	1	3	3	3	5	X		300 °C	3	3	3	5	X		300 °C	3	3	3	5	—
	400 °C	1	3	3	3	5	X		400 °C	3	5	5	5	X		400 °C	3	3	3	5	—
35m	200 °C	—	—	—	—	—	—	35m	200 °C	—	—	—	—	—	35m	200 °C	—	—	—	—	—
	300 °C	—	—	—	—	—	—		300 °C	—	—	—	—	—		300 °C	—	—	—	—	—
	400 °C	—	—	—	—	—	—		400 °C	—	—	—	—	—		400 °C	—	—	—	—	—

X : UNABLE TO HEAT — : NO CORRESPONDING MATERIAL

FIG. 6

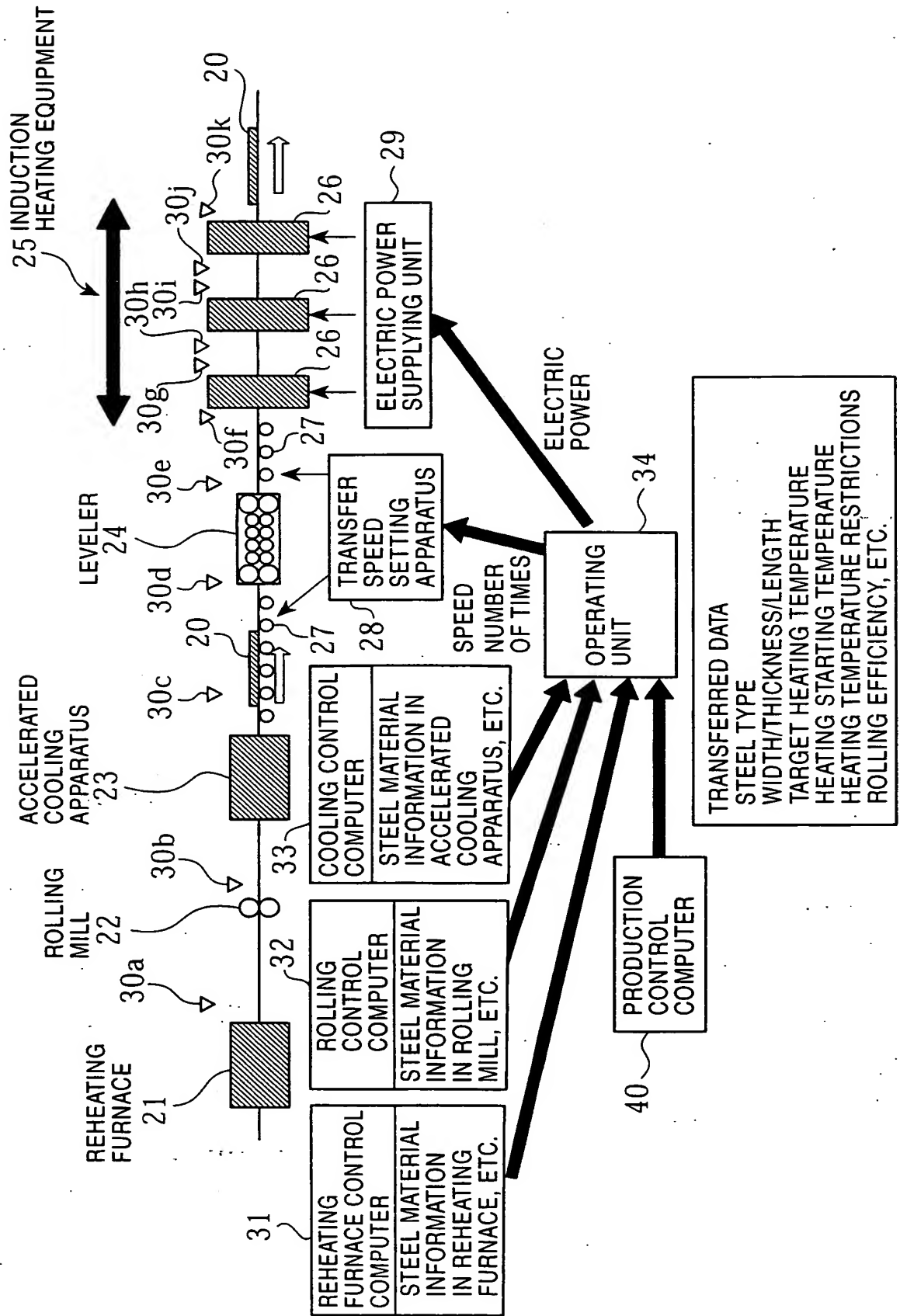


FIG. 7

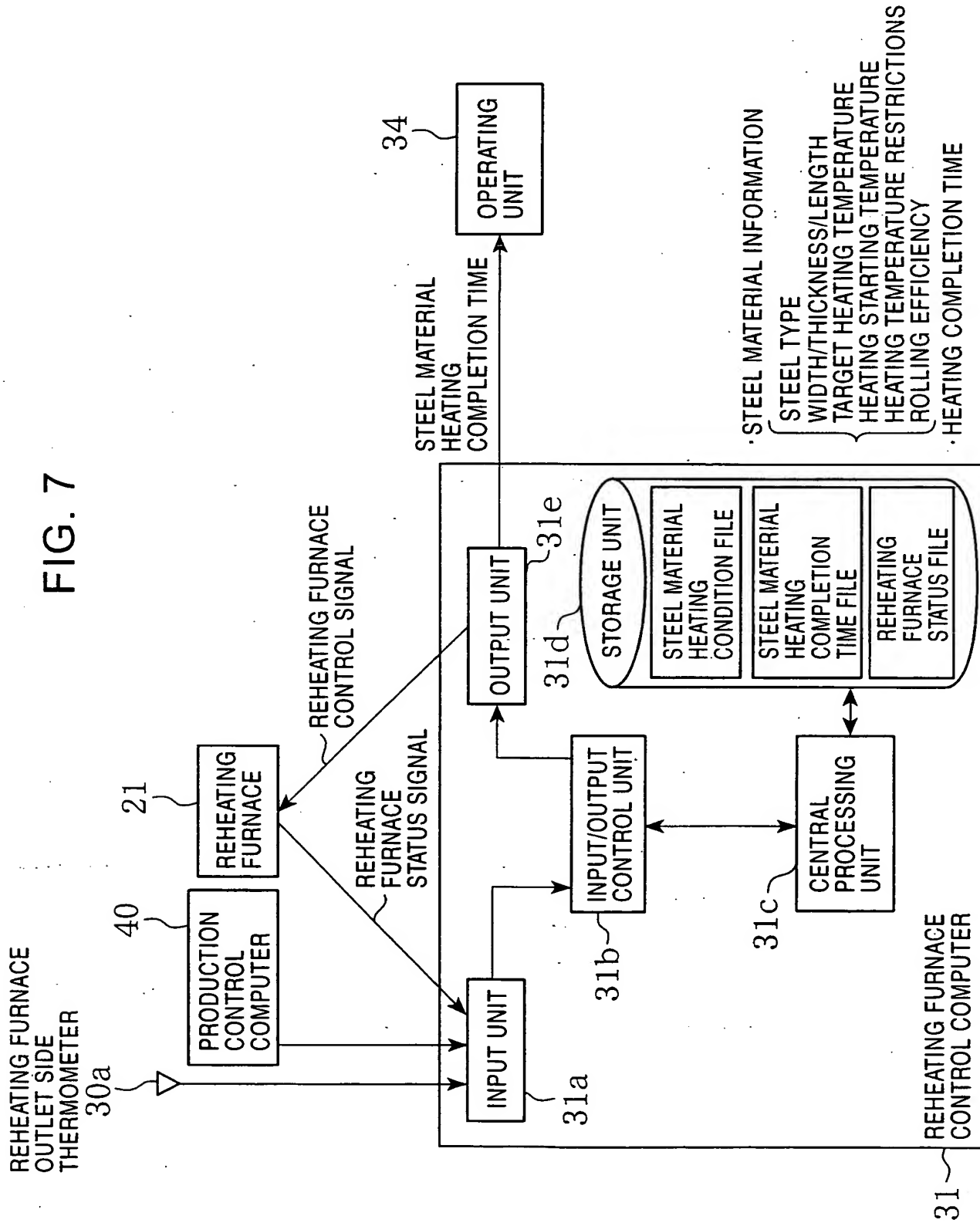


FIG. 8

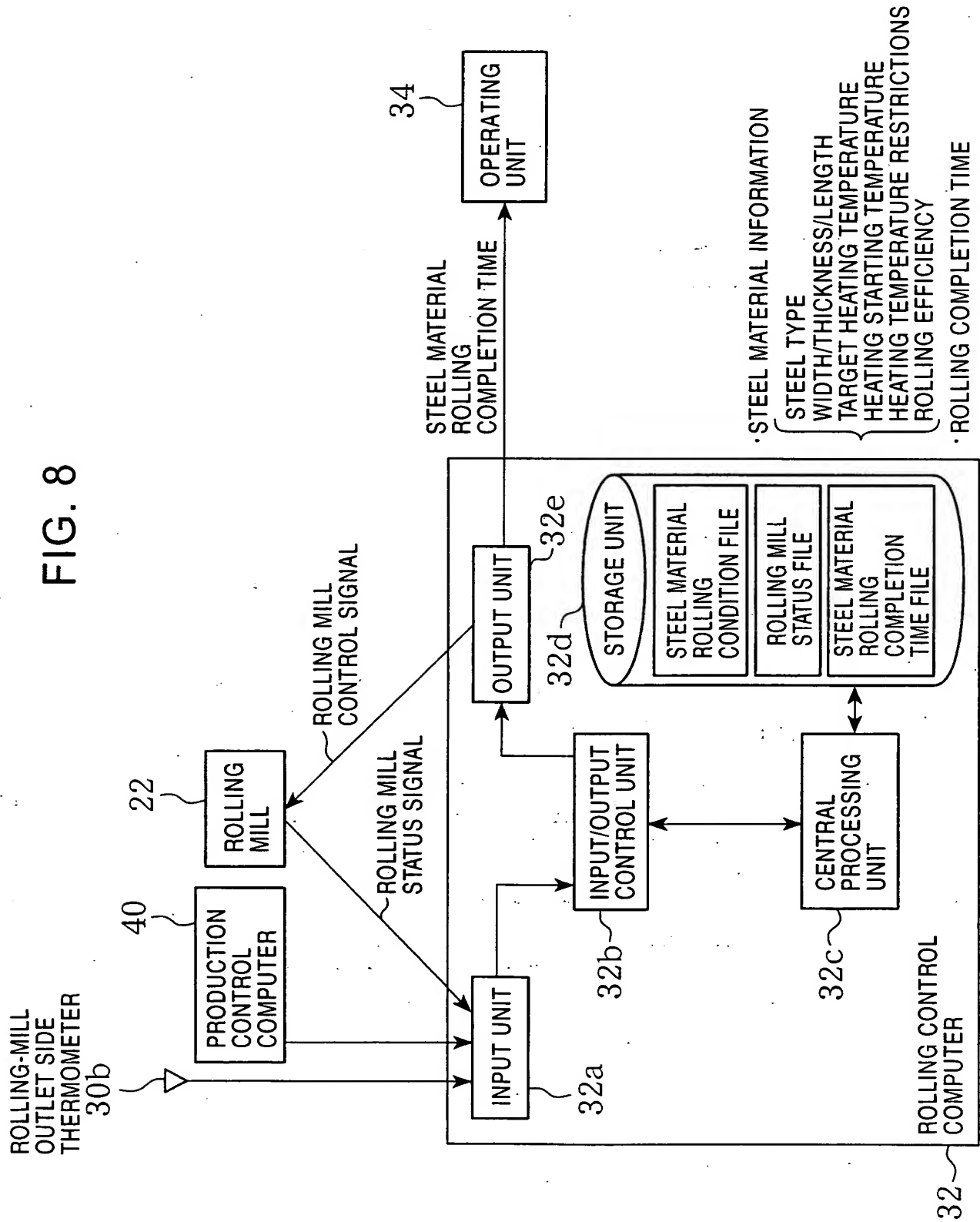


FIG. 9

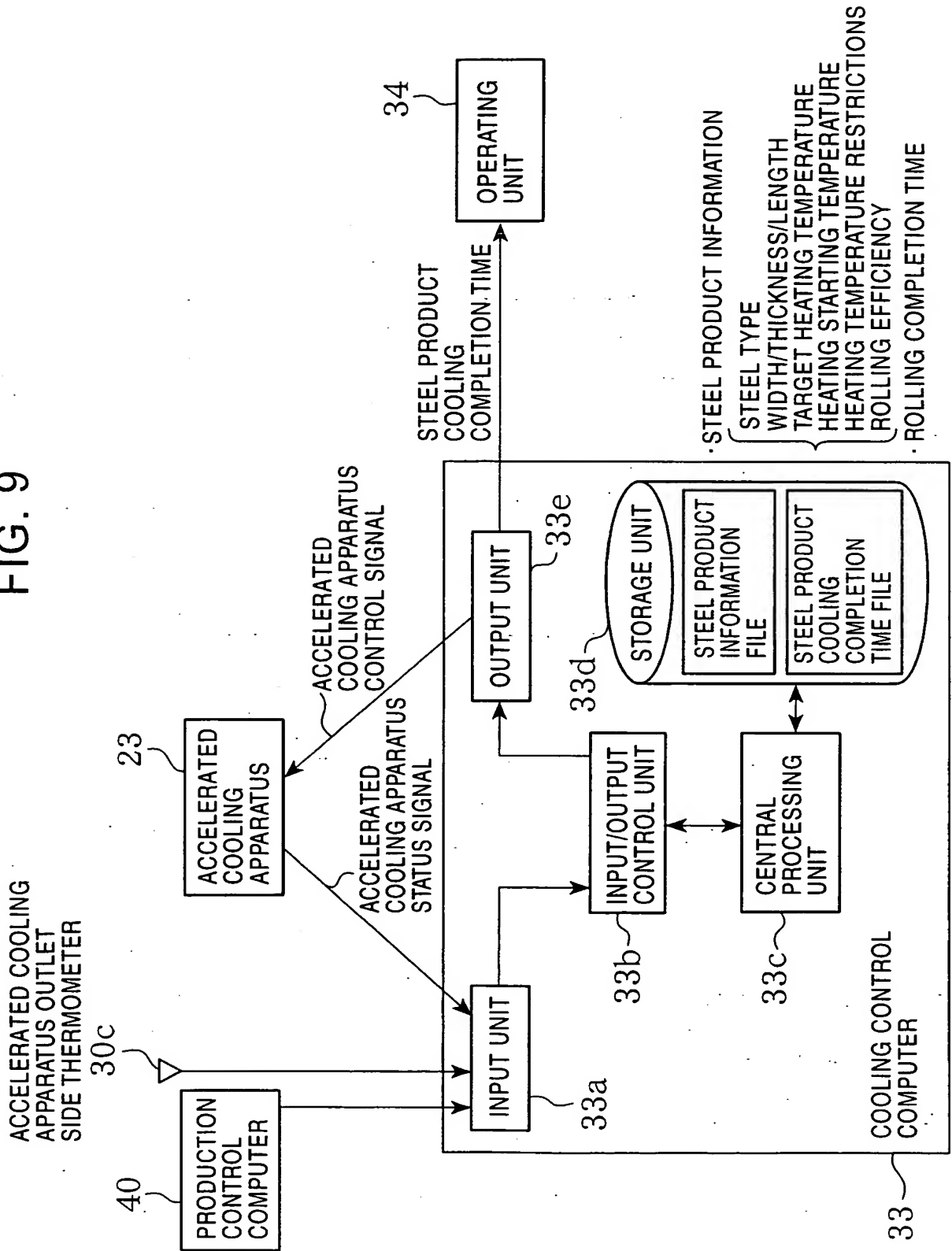


FIG. 10

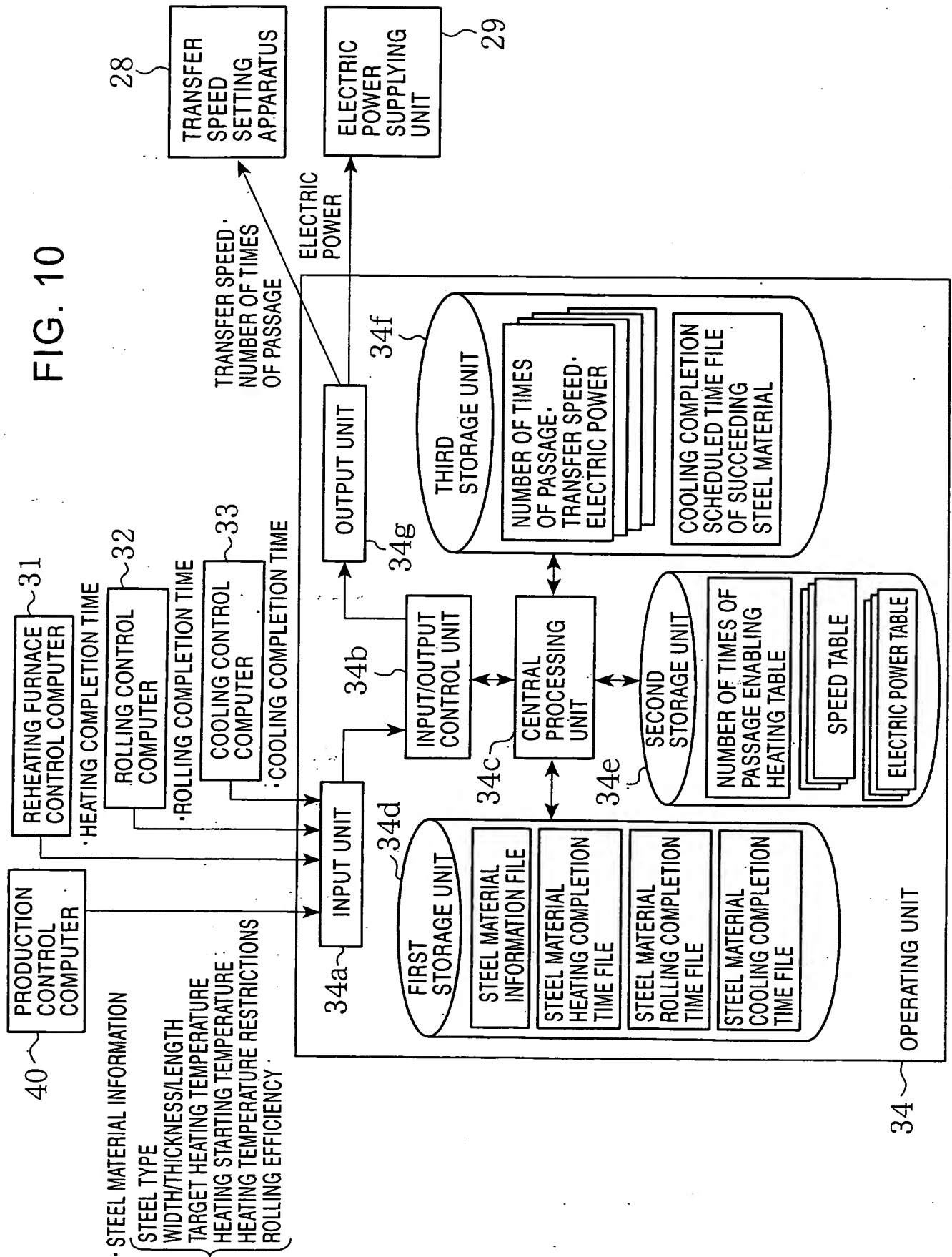


FIG. 11

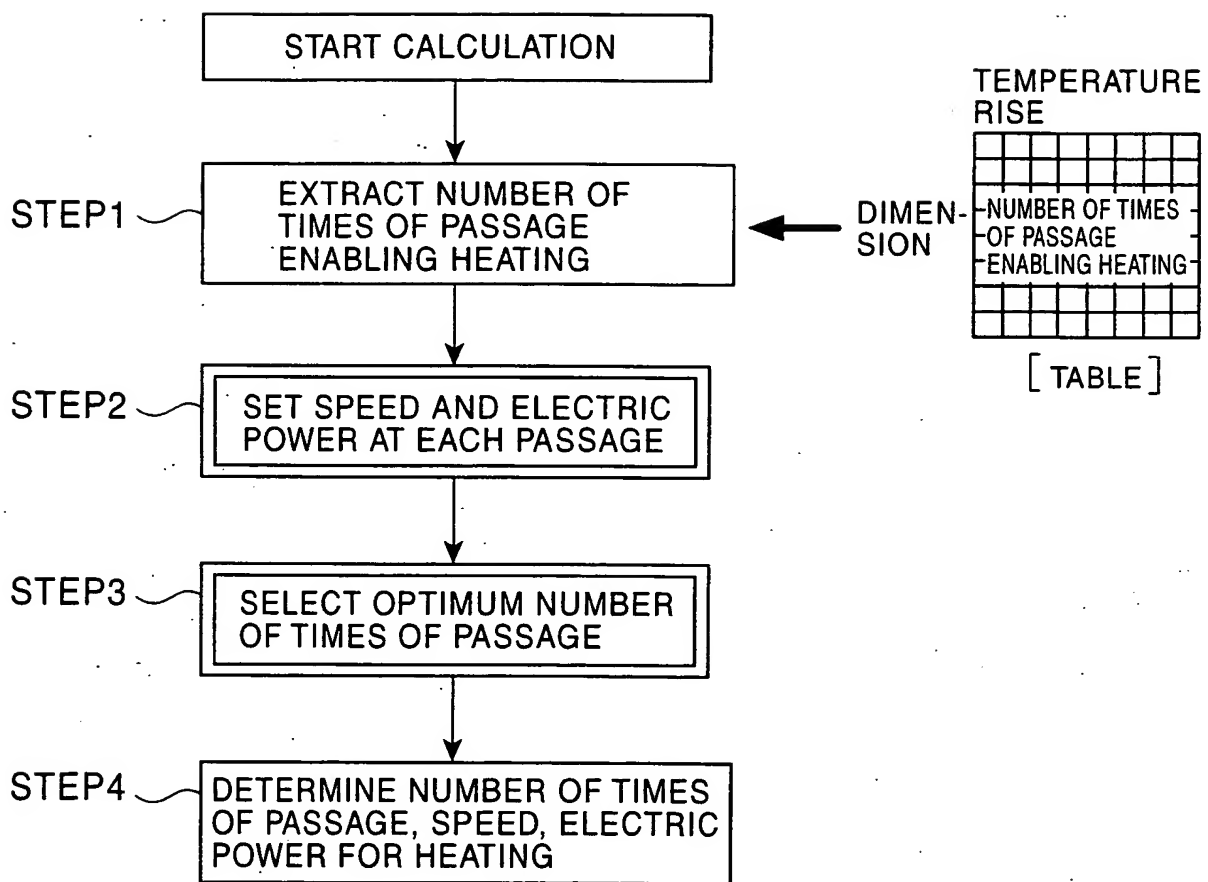


FIG. 12

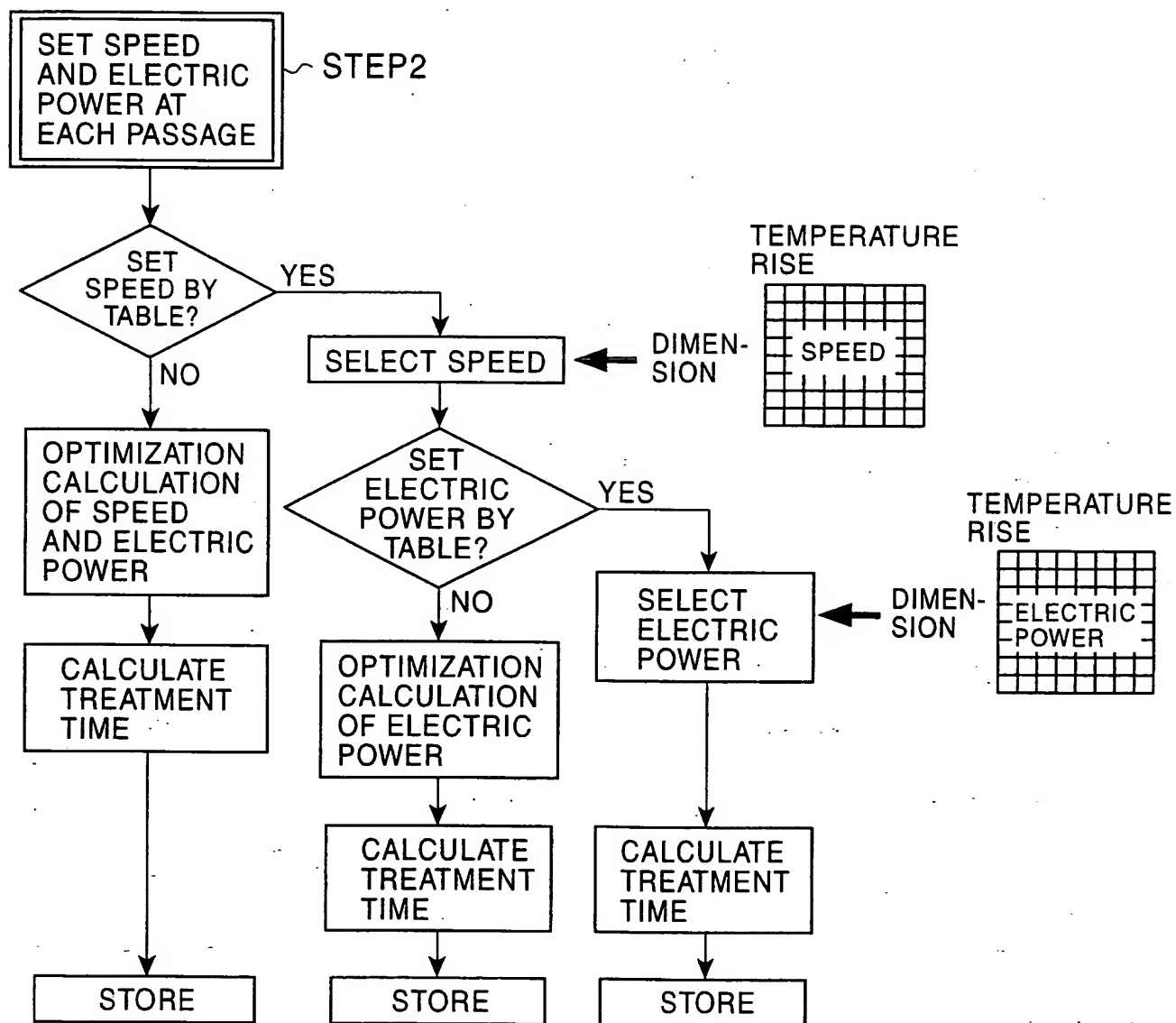


FIG. 13

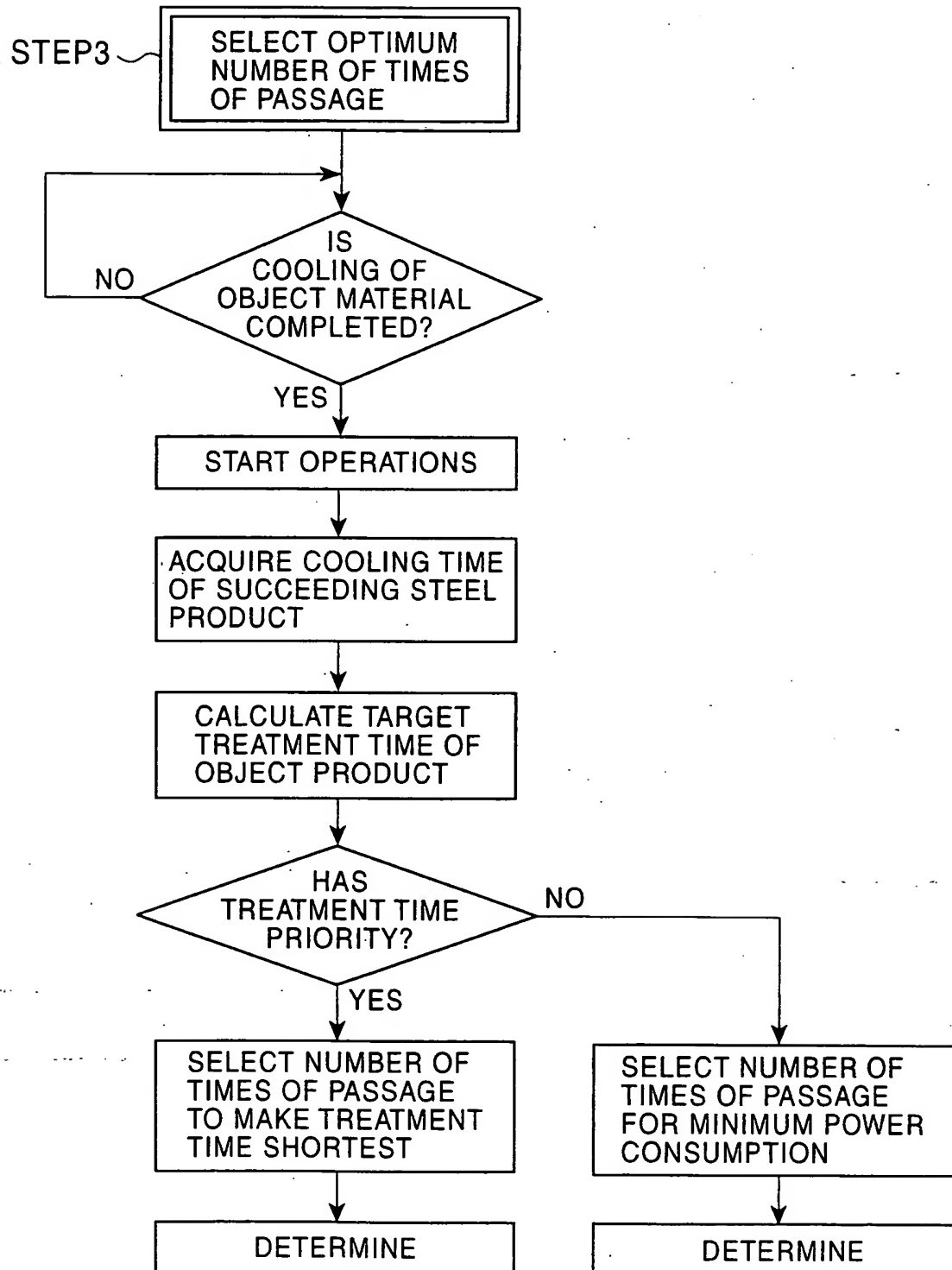


FIG. 14

